



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4032-041
Job Sheet 180575



Part No: D4032-041

Job Qty: 1 ea

Part Name: Short Basket Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/10/18

Job Tracking No:

Due Date: 7/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E SHEETS 1,3,4 IPP RevA: new issue DD 09.12.02 verified by:EC IPP Rev:B as per PA3 DD 10.03.10 verified by:EC IPP Rev:C as per RevA DD 10.03.23 verified by:EC IPP Rev:D as per dwg revC DD 10.04.20 verified by:EC IPP Rev:E as per dwg revD DD 10.08.18 verified by:EC

Ship Via:

004929.

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/20/18	7/20/18	0.00	0.00	Start Up Stores/Pkg-1		BEB 18-08-09
100	Packaging	1 pcs	7/20/18	7/20/18	0.00	0.00	Packaging1-4		BEB 18-08-09
110	HandFinish	1 pcs	7/20/18	7/20/18	0.00	1.16	HandFinish4		BEB 18-08-09
120	QC	1 pcs	7/20/18	7/20/18	0.00	0.00	QC5		PD 12-08-10
130	Packaging	1 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-2	08-6	AUG 10 2018
140	QC21-SA	1 Ea	7/20/18	7/20/18	0.00	0.00	QC21	9	AUG 10 2018

Part Op 110 - ****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ****

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-14A	Bolt	4 Ea (4 ea)	90-Start up Operation	5067270
AN3-16A	Bolt	2 Ea (2 ea)	90-Start up Operation	5045859-1
AN310-4	Nut	3 Ea (3 ea)	90-Start up Operation	5060062-1
AN310C4	Nut	2 Ea (2 ea)	90-Start up Operation	5065268
AN4-12	Bolt	3 Ea (3 ea)	90-Start up Operation	5064082.
AN5-17A	Bolt	4 Ea (4 ea)	90-Start up Operation	5068080
D2530	Handle Weldment	1 Ea (1 ea)	90-Start up Operation	5093529.
D2535	Spring	2 Ea (2 ea)	90-Start up Operation	5073832.
D2537	Bushing	2 Ea (2 ea)	90-Start up Operation	5097228
D3917-3	Washer	6 Ea (6 ea)	90-Start up Operation	5075567
D3953-17	Gas Spring Spacer	2 Ea (2 ea)	90-Start up Operation	5067458
D3953-19	Gas Spring Bracket	1 Ea (1 ea)	90-Start up Operation	5051316.
D3953-21	Gas Spring Bracket	1 Ea (1 ea)	90-Start up Operation	5051311
D3953-3	Gas Spring Stud, Lid	2 Ea (2 ea)	90-Start up Operation	5094876
D3953-7	Spring Spacer	2 Ea (2 ea)	90-Start up Operation	5097232.
D3953-9	Gas Spring Washer	2 Ea (2 ea)	90-Start up Operation	5075339.
D3969-3	Spring (Basket Lid)	1 Ea (1 ea)	90-Start up Operation	5079770
D4017-041	Short Basket Base Assembly (350)	1 Ea (1 ea)	90-Start up Operation	5095087.
D4018-041	AS350 Short Basket Lid Assembly	1 Ea (1 ea)	90-Start up Operation	5095085
MS21042L3	Nut	6 Ea (6 ea)	90-Start up Operation	5078253.
MS21042L5	Nut	4 Ea (4 ea)	90-Start up Operation	5041167
MS24665-151	Cotter Pin	3 Ea (3 ea)	90-Start up Operation	5053951-1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

MS24665-300	Cotter Pin	2 Ea (2 ea)	90-Start up Operation	5044188-1
NAS1149C0432R	Washer	2 Ea (2 ea)	90-Start up Operation	5050052-1
NAS1149F0332P	Washer	8 Ea (8 ea)	90-Start up Operation	5071415-1
NAS1149F0432P	Washer	6 Ea (6 ea)	90-Start up Operation	5050055-2
NAS1149F0563P	Washer	4 Ea (4 ea)	90-Start up Operation	5067901-2

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-14A	4	170	0
	AN3-16A	2	145	0
	AN310-4	3	175	0
	AN310C4	2	98	0
	AN4-12	3	125	0
	AN5-17A	4	168	0
	D2530	1	1	0
	D2535	2	44	0
	D2537	2	4	0
	D3917-3	6	75	0
	D3953-17	2	59	0
	D3953-19	1	36	0
	D3953-21	1	28	0
	D3953-3	2	10	0
	D3953-7	2	6	0
	D3953-9	2	41	0
	D3969-3	1	25	0
	D4017-041	1	0	0
	D4018-041	1	0	0
	MS21042L3	6	2,049	0
	MS21042L5	4	870	0
	MS24665-151	3	331	0
	MS24665-300	2	62	0
	NAS1149C0432R	2	1,607	0
	NAS1149F0332P	8	1,361	0
	NAS1149F0432P	6	2,779	0
	NAS1149F0563P	4	614	0

Part Specifications

Specifications could not be found.

Plex 7/10/18 11:10 AM Dart.lajeunesse.marie

DAR I
AEROSPACE

Container No: S100654

Part: D4032 - 041

Job No: 180575

Serial No/Batch: S100654

Revision:
Inspector:
Exp Date:
Instructions: Various STC's

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Markham, ON L3R 1K7
CANADA
TEL.: 913 632 - 8200
E-mail: sales@darson.com
www.darsonaerospace.com

Date: 08/09/10

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								